

Date: Monday, 6/19/2006 11:30:51 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STEP WELDMENT
<b>Job Number</b> : 27646	
<b>Estimate Number</b> : 10176	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2563
<b>This Issue</b> : 6/19/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2563 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 27404	<b>Material</b> : N/A
<b>Written By</b> : SEE COMMENT BELOW	<b>Due Date</b> : 7/10/2006
<b>Checked &amp; Approved By</b> : [Signature]	<b>Qty:</b> 2 <b>Um:</b> Each
<b>Comment</b> : Est Rev:G 02.07.31 Re-format Location RF	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D2244116	Step Extrusion
-----	----------	----------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

1 D2244 Step Extrusion

Batch: 323404

SE. 06.06.26

2

2.0	D267334	End Plate
-----	---------	-----------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part No. Description

2 D2673-34 End Cap

Batch

325396

SE. 06.06.26

2

3.0	D2561	Lug Plate
-----	-------	-----------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part No. Description

2 D2561 Lug Plate

Batch

327417 = 4

SE. 06.06.26

2

4.0	D2564	Mounting Angle
-----	-------	----------------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part No. Description

2 D2564 Mounting Angle

Batch

325970

SE. 06.06.26

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/19/2006 11:30:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 27646

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563

*PE. 06-06-26*

2

2-Deburr ends

*PE. 06-06-26*

2

3-Weld (1 End Only) as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M100660

*PE. 06-06-27*

2

4-Grind

*FF 06-06-27*

6.0

QC5/9

WELD INSPECTION



*PD 06-06-27*



*06-06-27*

2

Comment: WELD INSPECTION

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*M.F. 06/06/27*

②

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

*PE. 06-06-28*

2

2-Weld Remaining End as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M100660

*PE. 06-06-28*

2

3-Grind

*FF 06-06-29*

2

10.0

QC5/9

WELD INSPECTION



*QC9-5 PD 06-06-29*




*06-06-29*

Comment: WELD INSPECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/07/07

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/19/2006 11:30:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

D205-633-021

Job Number: 27646

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FF 06.06.29  
DLSC 07/04/06

2

(2)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

FC 06 07 04

(2)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Touch/6 (2)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/07/07 (2)

Job Completion



U 06-07-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

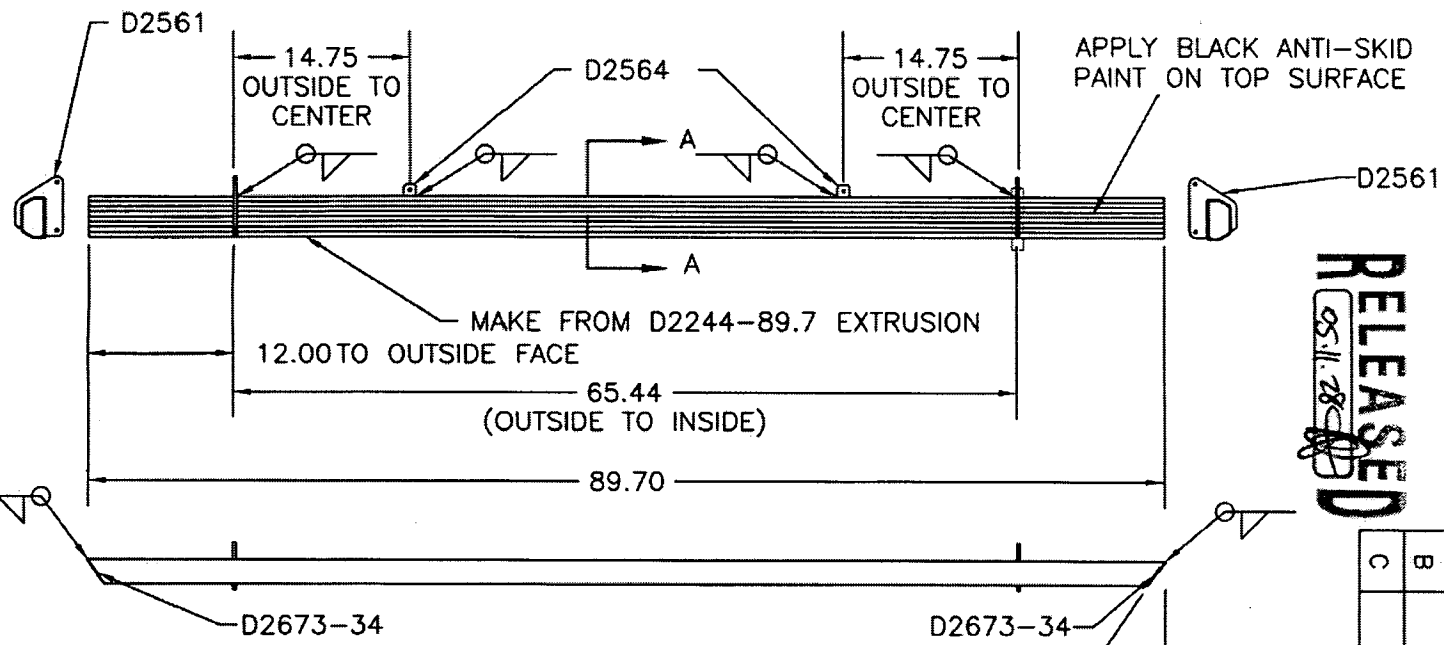
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



RELEASED  
05.11.28

DESIGN	BW	DRAWN BY	44	DART AEROSPACE LTD
CHECKED	44	APPROVED	44	HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	DRAWING NO.	D2563	REV. C
		TITLE	STEP WELDMENT ASSEMBLY	SHEET 1 OF 1
				SCALE 1:15
A	96.04.26	NEW ISSUE		
B	97.05.14	END CAPS CHANGED (WAS D2248)		
C	05.11.14	UPDATE NOTES		



**D2563 STEP WELDMENT ASSEMBLY PARTS LIST**

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

cut per drawing  
WORK ORDER  
27646  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
WITHOUT NOTICE

**D2563 STEP WELDMENT ASSEMBLY NOTES**

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE  
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 1996 by DART AEROSPACE LTD